

# Work Order ID 149287 - 1 split

Thursday, July 21, 2016 3:20:58 PM

\*149287\*

DRAB GREEN

Page 1

Item ID: D3407-041

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Tow Ring

Start Date: 9/20/2016 Start Qty: 10.00

\*10\*

Required Date: 9/30/2016 Req'd Qty: 10.00

\*10\*

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan: 21

DAS

9-89

Date:

JUL 22 2016

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3407

Rev E

100

0.00

\*100\*

Large Fab

Large Fab

Memo

0.30

Large Fab

Weld D3407-1/-5 using welding rod TIG174 as per Dwg D3407 & QSI 004  
A/R TIG174 ROD Batch: 102576

10

16-08-24  
JBL

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

\*110\*

QC

Memo

0.03

Quality Control

10 160826

DAS  
9  
9-89

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.03

Quality Control

10 160826

DAS  
9  
9-89

# Work Order ID 149287

Monday, July 25, 2016 7:13:26 AM

**\*149287\***

Page 2

Item ID: D3407-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Tow Ring

Start Date: 9/20/2016 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 9/30/2016 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

135

**\*135\***

Spray Paint

Spray Painting

Memo

PRIME B 135172  
SPRAY PAINT DRAB GREEN  
B 135413

0.00

0.00

2

DAS  
41  
9-89  
14.09.16

145

**\*145\***

QC

Quality Control

QC14- Inspect Spray Paint

Memo

0.00

0.00

2

DAS  
38  
9-89

SEP 15 2016

150

**\*150\***

Packaging

Packaging

Identify as per dwg & Stock Location: St 537

Memo

0.00

0.17

2

SEP 15 2016

DAS  
6  
9-89

**Work Order ID 149287**

Thursday, July 21, 2016 3:20:58 PM

**\*149287\***

Page 3

Item ID: D3407-041

Revision ID:

Item Name: Tow Ring

Start Date: 9/20/2016 Start Qty: 10.00

Required Date: 9/30/2016 Req'd Qty: 10.00

Reference:

Accept

**\*N900040100\***Setup Start **\*NS1\***Stop **\*NS2\***

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.02

Quality Control

MC 16-09-15

MC 16-09-15

# Picklist Print

Thursday, July 21, 2016 3:20:57 PM

Page 1

Work Order ID: 149287

**\*149287\***

Parent Item: D3407-041

**\*D3407-041\***

Parent Item Name: Tow Ring

Start Date: 9/20/2016

Required Date: 9/30/2016

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A05.10.14New issueKJ/EC  
IPP Rev:B 08-09-09 revE as per dwg DD verified by:EC

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D3407-1

Manufactured No

100 Each 50.0000

1

10

**\*\***

**\*D3407-1\***

Stem

Location

Loc Qty

Loc Code

WA001

50

144740

10

147320

40

10

D3407-5

Manufactured No

100 Each 7.0000

1

10

**\*\***

**\*D3407-5\***

Ring

Location

Loc Qty

Loc Code

WA001

7

145891

3

145892

4

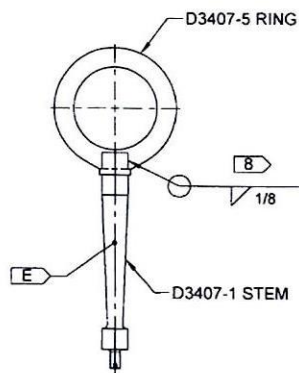
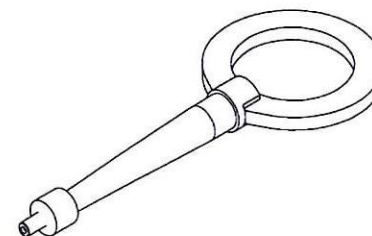
10

16-08-24  
JBL

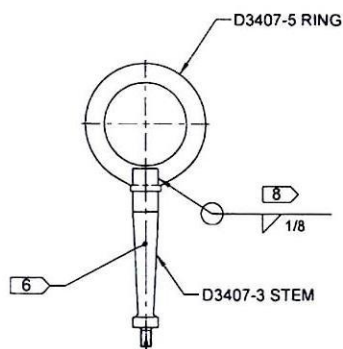
16-08-24  
JBL

| QTY -041 | QTY -043 | QTY -045 | PART NUMBER | DESCRIPTION |
|----------|----------|----------|-------------|-------------|
| X        |          |          | D3407-041   | TOW RING    |
|          | X        |          | D3407-043   | TOW RING    |
|          |          | X        | D3407-045   | TOW RING    |
| 1        |          |          | D3407-1     | STEM        |
|          | 1        |          | D3407-3     | STEM        |
| 1        | 1        | 1        | D3407-5     | RING        |
|          |          | 1        | D3407-7     | STEM        |

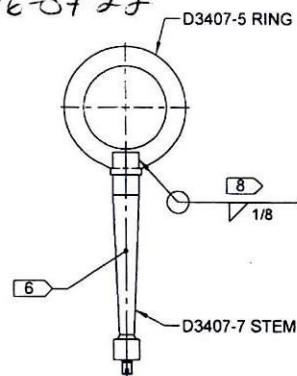
SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
EXCEPT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
149287ML5  
16-07-27



**D3407-041 TOW RING**



**D3407-043 TOW RING**



**D3407-045 TOW RING**

**RELEASED**  
07-08-21-1116

- NOTES:
- 1) MATERIAL: N/A
  - 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3 (EXCEPT THREADS)
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: N/A
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3407-XXX" USING BLACK FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: D3407-041 - 0.60 lbs, D3407-043 - 0.53 lbs, D3407-045 - 0.61 lbs
  - 8) WELD PER DART QSI 004 ON ALL EDGES BETWEEN STEM AND RING

|                                                                                                                                                                                                                                                                                                                                                                                                                                                                |                                                                                                                                                                                       |         |            |
|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|---------|------------|
| REV.                                                                                                                                                                                                                                                                                                                                                                                                                                                           | DESCRIPTION                                                                                                                                                                           | BY      | DATE       |
| E                                                                                                                                                                                                                                                                                                                                                                                                                                                              | ADD D3407-045 (ZN B2-1, D8-1); ADD D3407-7 (ZN B6-5); REVISED NOTE 6 TO ADD IDENTIFICATION (ZN A5-1); REASON: PRODUCTION FACILITY                                                     | PH      | 08.07.23   |
| D                                                                                                                                                                                                                                                                                                                                                                                                                                                              | D3407-1/3 SLOT WAS ROUND NOW FLAT FOR ASSEMBLY WITH D3407-5 (ZN C2-2, C2-3); D3407-5 WAS ROUND NOW FLAT ON ONE END FOR ASSEMBLY WITH D3407-1/3 (ZN B6-4); REASON: PRODUCTION FACILITY | PH      | 08.04.07   |
| C                                                                                                                                                                                                                                                                                                                                                                                                                                                              | -1/3 LONGER FOR FIT WWASHER                                                                                                                                                           | CP      | 05.09.09   |
| B                                                                                                                                                                                                                                                                                                                                                                                                                                                              | UPDATE DIAMETER, THREAD CLASS ADDED                                                                                                                                                   | CP      | 05.06.17   |
| A                                                                                                                                                                                                                                                                                                                                                                                                                                                              | NEW ISSUE                                                                                                                                                                             | CP      | 05.03.16   |
| DESIGN                                                                                                                                                                                                                                                                                                                                                                                                                                                         | DRAWN                                                                                                                                                                                 | CHECKED | MFG. APPR. |
| APPROVED                                                                                                                                                                                                                                                                                                                                                                                                                                                       | DE APPR.                                                                                                                                                                              | DATE    | 08.07.23   |
| <b>DART AEROSPACE USA, INC.</b><br>PORT HADLOCK, WA<br>DRAWING NO. <b>D3407</b><br>TITLE <b>TOW RING</b><br>REV. E<br>SHEET 1 OF 5<br>SCALE<br>NTS<br>COPYRIGHT © 2005 BY DART AEROSPACE USA, INC.<br><small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> |                                                                                                                                                                                       |         |            |